Work Ord <i>May 6, 2010 8:</i>		410							April 10 to	:		Page 1
Item ID: Revision ID: Item Name:	DSK080	NING DETAIL		Accept					Setup	Start Stop		
Start Date: Required Date Reference:	06/05/2010	Start Qty: 10.00 Req'd Qty: 10.00	1150101		Cust Ite Custom		-	-				
Approvals:	Process Pla	in:	Date:/ <i>O-5-OS</i>	Tooling:SPC (Y/N):		Date:			Run	Start Stop		1 1 1 1 1 1 1 1 1 1
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Draw (Plan Code	Accept Qty	t Reje		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr						(C-1)				- Stamp
DSK080	Rev	Α								ļ		
Doosan Lathe		MORI SEIKI CNC LA Memo Turn blan	NTHE LARGE k as per Folio FA167	0.00	- 10/c	54/10		(10))			
QC Quality Control		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00 0.00	- 10/0	7/10	(h	·		- 1	· ———
120 		QC8- Inspect parts - so	econd check	0.00 J) 10/e	7/12					·:	

Memo

Quality Control

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** DATE **Approval** STEP PROCEDURE CHANGE By **Date** Qty Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ QA: N/C Closed: ____ ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval Approval** Initial **Action Description** Sign & Section A Section C Chief Eng QC Inspector Chief Eng Chief Eng Date

W٥	rk	Or	der	ID	58410	n
* * •		\mathbf{v}	4	11/	~!!!	

May 6, 2010 8:28:01 AM

Required Date: 13/05/2010



Page 2

Item ID:

Revision ID: Item Name:

DSK080

Accept

Setup Start

Start Date:

06/05/2010

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: ____ Date: ___ Tooling:

QC:

D2896-1 TURNING DETAIL

Date:

Date:

Start

Stop

Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Packaging

Set Up/ **Run Hours**

SPC (Y/N):

0.00

Memo Identify and Stock in Kanban Location: CNC

Date:

Draw Number

Draw Plan Rev. Code

Accept Qty

Qty.

Run

Reject Reject

Insp. Number Stamp

140

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

Dart Aerospace Ltd

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W/O:		,	W	ORK ORDER CHANG	ES			1 -	ฉี
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	dty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:		Date:	
	Re	esolution:	Disposition	n:	_ QA: N/C C	losed:	<u> </u>	Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	٦)			
DATE	STEP	Description of NC		Corrective Action Section		Verifica	tion	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Section		Chief Eng	QC Inspector
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Picklist Print	<u> </u>				<u> </u>	·							
May 6, 2010 8:28:							•				!		Page 1
Work Order ID: 58	8410									···	!	·	**
Parent Item Name:	SK080 D2896-1 TURNINC						;	s	tart E	 ate: 06/0	5/2010	Required Da	ate: 13/05/2010
Comments:	IPP rev A. 08.03.1	3 new issue	EC				!	9	Start	Qty: 10.0	0	Required Q	ty: 10.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty	per Kit	Qty Issued	Date Issued	Status
D6104-011 17-4 SS Roundbar 6.50'		Manufactured	No				Each	10.0000		1			
				Location MAT43	41969	<u>Loc (</u>	Oty 10 10	Loc Code			10		0/07/16

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER C	HANGES			- -		τ,
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			<u>-</u>							
		•								
Part No	•	PAR #:	Fault Cat	egory:	N	CR: Yes	No DQA	:	Date: _	
		esolution:						1	Date:	
NCR:		V	VORK ORE	ER NON-CONF	ORMANO	E (NCR)			
DATE	STEP	Description of NC		Corrective Action			Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Desci Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
						1.				
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NOTE					•					

SHOP COPY **RETURN TO ENGINEERING** DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA UNCONTRO H H SUBJECT TO A APPROVED CHECKED DRAWING NO. REV. A WITHOU14 **DSK 080** WORK ORDER SHEET 1 OF 1 DATE TITLE NO. 58916 SCALE 03.05.20 TURNING DETAIL FOR D2896-1 03.05.20 **NEW ISSUE** DELFASEI 03.57.01 ø6.500 (I 0.728 (TYP) 0.100 - ø3.715 (TYP) (F E) (TYP) ø3.835 (TYP) ø3.480^{+0.005} 0.117 (TYP) K R0.032 (TYP) R0.250 J (TYP) 1.370 D2896-1 (TYP) TURNING DETAIL $.260_{\,-0.010}^{\,0.000}$ В 4.000

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Dart Aerospace Ltd

W/O:	•		W	ORK ORDER CHAN	GES			1		· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Cty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No.	•	PAR #:	Foult Cat		NOD					
raitivo		esolution:								
NCR:		Υ·		DER NON-CONFORM					Date	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	etion B	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
	<u>:</u>									
NATE O										

DART AEROSPACE LTD	Work Order:	58410
Description: Turning Detail for D2896-1	Part Number:	DSK080
Inspection Dwg: DSK080 Rev: A		Page 1 of 1

		FIRST	ARTICLE IN	SPECTION	DIMENSI	ON SHEE	т	
			X First	Article	Proto	type		
					Record	Actual Dim	ensions	
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
				Lathe Section	on			
Α	3.480	3.485		3.480	3.480	3.480	13480	13.480
В	3.990	4.010		4.001	4.002	4.000	4.000	4.000
С	3.825	3.845		3.835	3.835	3.835	3.835	3.535
D	0.718	0.738		-728	-728	1728	-728	.728
E	0.090	0.110		.101	.101	1 -101	-161	./01
F	3.705	3.725		3.7/6	3.716	-37/6	3716	3.716
G	1.360	1.380		1.373	1.373	1.373	1-373	17-373
Н	1.250	1.260		1.258	1.257	1.257	1257	1.257
I	6.490	6.510		6.498	6-498	6.499	6-499	6-499
J	0.022	0.042		- 032	-032	.032	-03a	. 032
K	0.240	0.260		.250	,250	-250	250	-250
L	0.107	0.127		-119	. 119	- 119	-119	-119
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Rev	Date	Change			_	Re	vised by _N	Approv <i>e</i> d
Α	08.04.22	New Issue			· (,,		JLM A	

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** DATE **STEP Approval PROCEDURE CHANGE** By Chief Eng / Prod Mgr Date Qty QC Inspector Part No: _____ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ____ Disposition: _____ QA: N/C Closed: ____ Date: ____ **Resolution:** WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Description of NC Section B Verification DATE **STEP Approval Approval** Sign & Initial **Action Description** Section A Section C QC Inspector Chief Eng Chief Eng Chief Eng Date 4 1 *

DART AEROSPACE LTD	Work Order:	58410
Description: Turning Detail for D2896-1	Part Number:	DSK080
Inspection Dwg: DSK080 Rev: A		Page 1 of 1

						ON SHEE		
		•	X First	Article	Proto	type		
					Record	Actual Dim	ensions	/ <u>-</u>
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
				Lathe Section	on		,	<u> </u>
Α	3.480	3.485		3.480	13.480	13 480	13 480	13 480
В	3.990	4.010		4-001	4-001	4.000	4,000	4-000
С	3.825	3.845		3.835	3.835	3.835	3.835	3.835
D	0.718	0.738		1-728	-728	.728	-728	-7a8
Е	0.090	0.110		-101	101	-101	100	-101
F	3.705	3.725		3.716	3.716	13.7/6	3.716	3.76
G	1.360	1.380		1.343	1.373	1373	1-373	1273
Н	1.250	1.260		1,857	1-258	1.257	1-254	1-257
ı	6.490	6.510		6-1199	6 499	6,499	6.499	6 499
J	0.022	0.042		-032	.632	.032	-032	.032
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